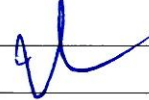


Work Order ID 164560***164560***

Page 1

Friday, July 21, 2017 12:39:33 PM

Item ID: D2432 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: ***NS2*** Stop
Item Name: Bearpaw 19" X 24"
Start Date: 7/21/2017 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 8/9/2017 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2432	H								

120

0.00

120

FLOW WATER JET

Waterjet

Memo

3.15

FLOW CNC Waterjet

Cut Blank as per D2432 File



130

0.56

130

HAAS CNC VERTICAL MACHINING #1

HAAS 1

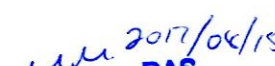
Memo

9.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio and Dwg D2432 Identify as D2432F
3-Deburr




2017/06/15
DAS
49
9-89
17/08/12

140

0.00

140

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.20

Quality Control



DAS
49
9-89
17/08/13

Work Order ID 164560

Friday, July 21, 2017 12:39:33 PM

164560

Page 2

Item ID: D2432

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bearpaw 19" X 24"

Start Date: 7/21/2017 Start Qty: 20.00

20

Cust Item ID:

Required Date: 9/8/2017 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							
150						20	0		DAS 45 9-89
QC	Memo	0.40							2017-8-15
Quality Control									
160	Identify as per dwg & Stock Location: <u>51</u>	0.00				20			
160									
Packaging	Memo	0.20							
Packaging									AUG 15 2017
170	QC21- Final Inspection - Work Order Release	0.00							
170									DAS 21 9-89
QC	Memo	2.00							AUG 16 2017
Quality Control									

DAS
21
9-89

AUG 15 2017

Picklist Print

Friday, July 21, 2017 12:39:31 PM

Page 1

Work Order ID: 164560

164560

Parent Item: D2432

D2432

Parent Item Name: Bearpaw 19" X 24"

Start Date: 7/21/2017

Required Date: 9/8/2017

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 12.10.17 AS PER DWG REV.H DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased				120	sf	519.5730	3.7	74			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

**

26 17/07/25

Location

Loc Qty

Loc Code

MAT018

519.573

m136453

200

m137443

319.573

74

DART AEROSPACE LTD		Work Order: 164560
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432	Rev: H	Page 1 of 1

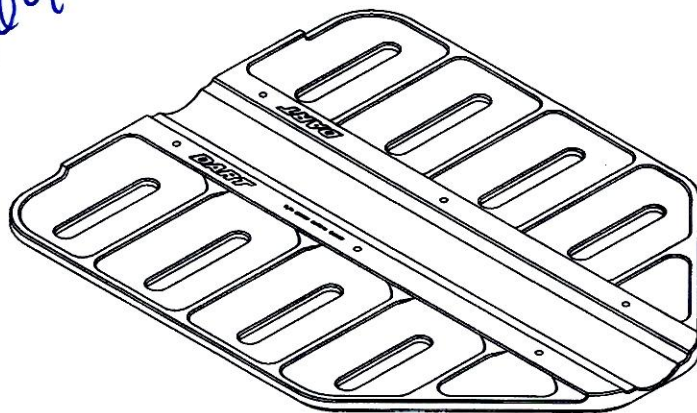
FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.060 x 45°	/		vern	mm L-05
B	0.200	+/-0.030	0.201	/		↓	
C	0.25 x 45°	+/-0.030	0.240 x 45°	/		↓	
D	R0.250	+/-0.030	0.250	/		R6	
E	0.250	+/-0.010	0.241	/		vern	mm L-05
F	0.625	+/-0.030	0.615	/		↓	
G	0.375	+0.030/-0.010	0.381	/		↓	
H	0.950	+/-0.030	0.951	/		↓	
I	19.000	+/-0.030	19.00	/		tape	
J	Ø0.260	+0.005/-0.000	0.261	/		vern	mm L-05
K	Ø0.93	+/-0.030	0.929	/		↓	
L	0.30	+0.030/-0.000	0.307	/		↓	
M	23.750	+/-0.030	23.750	/		tape	
N	2.000	+/-0.030	2.015	/		vern	mm L-05
O	0.38	+/-0.030	0.379	/			
P							
Q							
R							
S							
T							
U							
V		DAS 49		DAS 45			

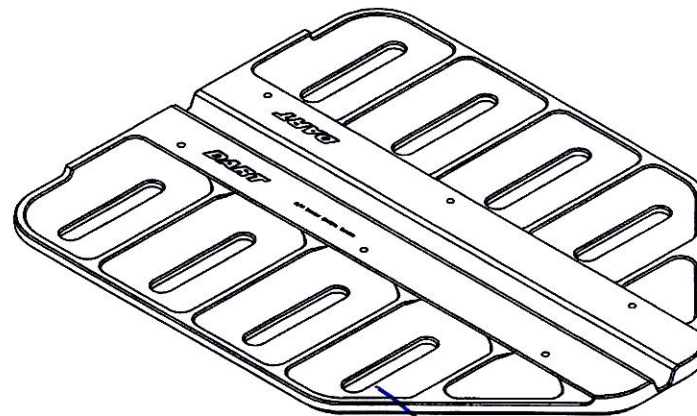
Measured by: 9-89	Audited by: 9-89	Preliminary Approval:
Date: 17/08/13	Date: 2013-8-15	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O D206-559-015	KJ/RF	
B	12.07.31	Dwg Rev updated	KJ	
C	12.10.26	Dwg Rev updated	KJ	
D	13.07.18	Dimension 7.375 removed	KJ	
E	15.02.09	Dimensions revised	KJ	

104560



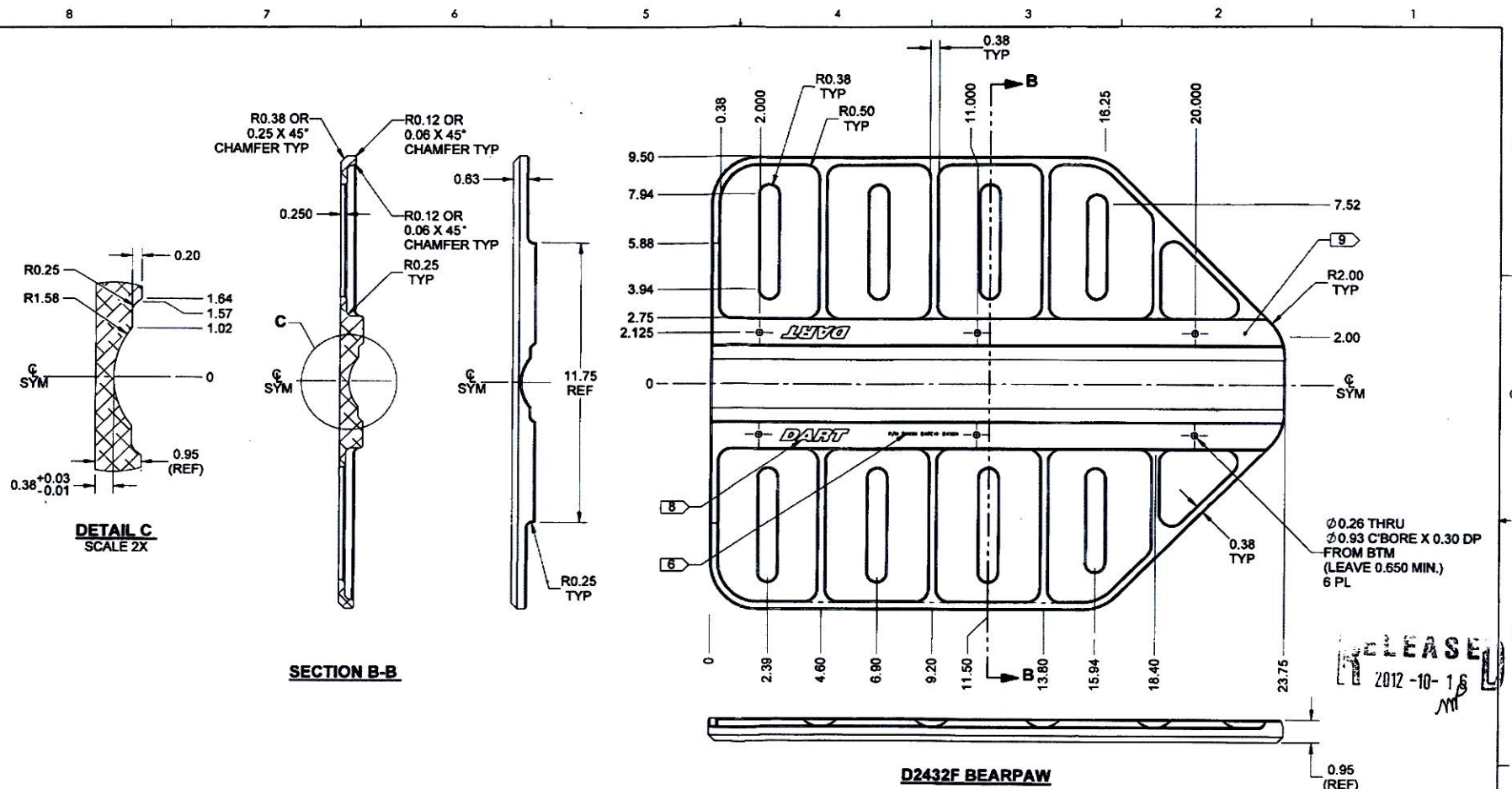
D2432F BEARPAW



D2432-3 BEARPAW

RELEASED
2012-10-16

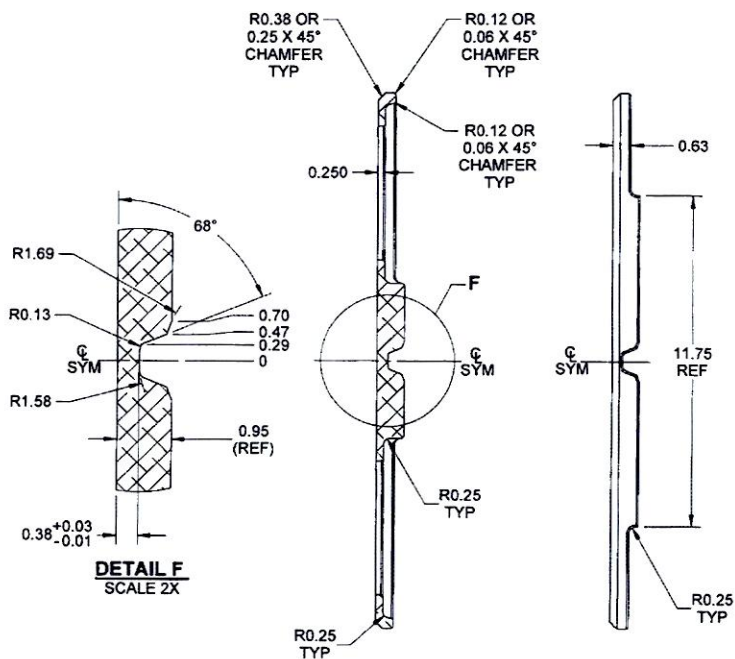
H	RIB HEIGHTS CHANGED TO CONDITION OF REV. F. SEE REV. F FOR DETAILS.	AP	12.09.24
G	UPDATE DRAWING FORMAT, REMOVED D2432B, ADD D2432-3, ADDED DIMENSION 7.52 (D1-2)	AP	12.05.02
F	CHANGE C'BORE, ADD B AND F P/N	-	98.05.12
E	CHANGE C'BORE DEPTH, BORE RADIUS	-	97.02.27
D	MOVE SLOT	-	96.06.04
C	CHANGE BORE AND C'BORE DEPTH	-	96.03.26
B	RE-DESIGN	-	96.01.24
A	NEW ISSUE	-	95.10.31
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AS	DRAWING NO.	REV. H
MFG. APPR.	AT	D2432	SHEET 1 OF 3
APPROVED	AD	TITLE	SCALE
DE APPR.	AT	BEARPAW	NTS
DATE	12.09.24	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



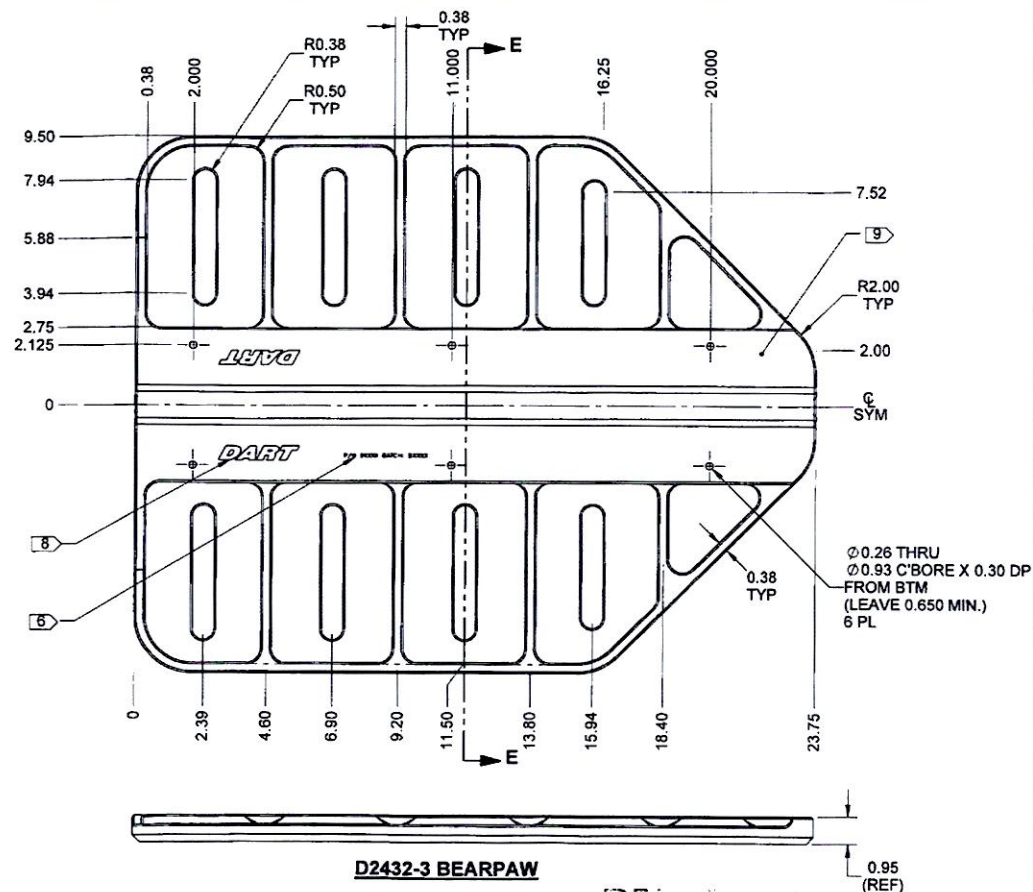
NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.000 THICK MACHINED TO 0.950 (REF DART SPEC. MUHMWB10)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER "D2432" AND BATCH NUMBER "BXXXXX" IN ACCORDANCE WITH QSI 044 METHOD 6.3
- 7) WEIGHT: 5.87 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.012
- 9) APPLY 0.06 x 45° CHAMFER TO ALL EDGES ON SIDE SHOWN UNLESS OTHERWISE INDICATED
- 10) PROFILE PER DRAWING FILE "D2434F-REVH.STP"

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. H
MFG. APPR.	91	D2432	SHEET 2 OF 3
APPROVED	16	TITLE	SCALE
DE APPR.	16	BEARPAW	NTS
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SECTION E-E



D2432-3 BEARPAW

REL 2012-10-16

NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.000 THICK MACHINED TO 0.950 (REF DART SPEC. MUHMWB10)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER "D2432-3" AND BATCH NUMBER "BXXXXX" IN ACCORDANCE WITH QSI 044 METHOD 6.3
- 7) WEIGHT: 6.25 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.012
- 9) APPLY 0.06 x 45° CHAMFER TO ALL EDGES ON SIDE SHOWN UNLESS OTHERWISE INDICATED
- 10) PROFILE PER DRAWING FILE "D2432-3-REVH.STP"

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. H
MFG. APPR.	21	D2432	SHEET 3 OF 3
APPROVED	10	TITLE	SCALE
DE APPR.	11	BEARPAW	NTS
DATE	12.09.24	COPYRIGHT © 1996 BY DART AEROSPACE LTD	
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